



SPLIT

DART AEROSPACE LTD	Work Order:	22167B
Description: Dual Disabling Device	Part Number:	D350-740-011
	Keyed:	<input type="checkbox"/> Alike <input checked="" type="checkbox"/> Unalike
Dwg: D3371 Rev. A; D3372 Rev. A	Qty:	15
Page 1 of 4		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Travelers for: D350-740-011 Dual Disabling Device D3371-1 Pedal Lock Base D3371-3 Pedal Lock Cover D3372-1 Main Body D3372-7 Slider Body D3373-7 Cam Lock D3373-11 Cam Lock D3384-1 Cyclic Sock D3385-1 Hinge			
		Batch 22167B 22167B 22167B 22167B 22167B 22167B 22167B 22167B 22167B	HA	05.01.18	15
2	DC	Photocopy bluefile and create labels per PPP D350-740-011 CHG001	HA	05.02.01	18
3	GA	Pick: Qty Part Number Description Batch 1 D3371-1 Pedal Lock Base B 22167B 1 D3371-3 Pedal Lock Cover B 22167B 1 D3385-1 Hinge B 22271	SB	05/01/24	11
4	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Mask threaded holes	MM	05/01/22	15
5	QC3	Inspect Powder Coat	SB	05/01/25	11
6	GA	Press dowel pins as per Dwg D3372, then assemble hinge. Ensure that assembly opens & closes smoothly. Pick: Qty Part Number Description Batch 1 D2728-7 Decal M 116632 M 15464 1 D3373-7 Cam Lock B 22160 4 AN526C832R6 Screw M 2039 2 N/A Ø3/16" Dowel Pin 1/2" long M 116485	SB	05/01/25	17
7	GA	Open D3373-7 lock package. Keep keys, lock body, lock body nut, straight cam, lock barrel, screw, 90° rotation washer and external tooth lock washer. Discard the rest.	SB	05/01/24	11
8	GA	Fabricate D3371-5 cam as per Dwg D3371 Identify as D3371-5	SB	05/01/25	11
9	GA	Assemble lock mechanism and cam and install decal as per Dwg D3371	SB	05/01/25	11
10	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: Qty Part Number Description Batch 1 D3384-1 Cyclic Sock B 22149C 2 CBL-460 Loop Sleeve M 15694 22" CBL-1240 Cable M 1435 Identify as D3384-045	SB	05-01-25	11
11	GA	Assemble D3384-045 to D3371-051 using 1/4"-20 socket head cap screw and washer as per Dwg D3371. Pick: Qty Part Number Description Batch 2 AN960-416 Washer M 5519 1 HX-81 1/4"-20 SHCS 3/8" long M 16520 Identify as D3371-041 & attach keys Record the Key Number on page 4	SB	05-01-26	11

RELEASED

Bd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-01/27	11	Sian took 1 for HAI	U	05/01/27	1	U	 000112	
05/01/27	11	Stock 24 D 3371-1	SJB	05/01/27	2	U	 000112	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22167B
Description: Dual Disabling Device		Part Number:	D350-740-011
		Keyed:	<input type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3371 Rev. A; D3372 Rev. A		Qty:	15
		Page 2 of 4	

Step	Location	Procedure	By	Date	Qty																												
12	QC5	Inspect work to Step 11	SB	05-01-26	29																												
13	GA	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3372-1</td> <td>Main Body</td> <td>B 22167B</td> </tr> <tr> <td>1</td> <td>D3372-5</td> <td>Cam Lock Shaft</td> <td>B 22167B</td> </tr> <tr> <td>1</td> <td>D3372-7</td> <td>Slider Body</td> <td>22167B</td> </tr> <tr> <td>1</td> <td>D3373-11</td> <td>Cam Lock</td> <td>B22231</td> </tr> <tr> <td>1</td> <td>AN5-42A</td> <td>Bolt</td> <td>M 387611</td> </tr> <tr> <td>1</td> <td>AN5-44A</td> <td>Bolt on 11</td> <td>M 1973 (13)</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3372-1	Main Body	B 22167B	1	D3372-5	Cam Lock Shaft	B 22167B	1	D3372-7	Slider Body	22167B	1	D3373-11	Cam Lock	B22231	1	AN5-42A	Bolt	M 387611	1	AN5-44A	Bolt on 11	M 1973 (13)	SB	05/01/26	29
Qty	Part Number	Description	Batch																														
1	D3372-1	Main Body	B 22167B																														
1	D3372-5	Cam Lock Shaft	B 22167B																														
1	D3372-7	Slider Body	22167B																														
1	D3373-11	Cam Lock	B22231																														
1	AN5-42A	Bolt	M 387611																														
1	AN5-44A	Bolt on 11	M 1973 (13)																														
14	GA	Fabricate D3372-3 using AN5-42A bolt as per Dwg D3372 Identify as D3372-3	SB	05/01/26	29																												
15	QC5	Inspect work to Step 14	SB	05-01-26	29																												
16	GA	Open Cam Lock package. Keep keys, lock body, lock body nut, flat cam and lock barrel. Discard the rest.	SB	05/01/26	29																												
17	GA	Fabricate D3372-11 spacer using the flat cam as per Dwg D3372 Identify as D3372-11	SB	05/01/26	29																												
18	GA	Assemble D3372-055 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>Locktite 262</td> <td>M 16517</td> </tr> </tbody> </table> Identify as D3372-055	Qty	Part Number	Description	Batch	A/R	N/A	Locktite 262	M 16517	SB	05/01/26	29																				
Qty	Part Number	Description	Batch																														
A/R	N/A	Locktite 262	M 16517																														
19	GA	Assemble D3372-053 as per Dwg D3372. Apply a drop of permanent locktite 262 to the threads. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3372-11</td> <td>Washer</td> <td>B 22167B</td> </tr> <tr> <td>1</td> <td>5/16WC</td> <td>SS Flat Washer</td> <td>M 15715</td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>Locktite 262</td> <td>M 16517</td> </tr> </tbody> </table> Identify as D3372-053	Qty	Part Number	Description	Batch	1	D3372-11	Washer	B 22167B	1	5/16WC	SS Flat Washer	M 15715	A/R	N/A	Locktite 262	M 16517	SB	05/01/26	29												
Qty	Part Number	Description	Batch																														
1	D3372-11	Washer	B 22167B																														
1	5/16WC	SS Flat Washer	M 15715																														
A/R	N/A	Locktite 262	M 16517																														
20	GA	Assemble D3372-051 as per Dwg D3372. Identify as D3372-051 and attach keys Ensure that assembly locks and unlocks smoothly.	SB	05/01/26	29																												
21	QC5	Inspect work to Step 20	SB	05-01-26	29																												
22	GA	Assemble lanyard to cyclic sock as per Dwg D3384 Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3384-1</td> <td>Cyclic Sock</td> <td>B72149C</td> </tr> <tr> <td>2</td> <td>CBL-460</td> <td>Loop Sleeve</td> <td>M 15699</td> </tr> <tr> <td>22"</td> <td>CBL-1240</td> <td>Cable</td> <td>M 7430</td> </tr> </tbody> </table> Identify as D3384-043	Qty	Part Number	Description	Batch	1	D3384-1	Cyclic Sock	B72149C	2	CBL-460	Loop Sleeve	M 15699	22"	CBL-1240	Cable	M 7430	SB	05-01-26	31												
Qty	Part Number	Description	Batch																														
1	D3384-1	Cyclic Sock	B72149C																														
2	CBL-460	Loop Sleeve	M 15699																														
22"	CBL-1240	Cable	M 7430																														
23	GA	Assemble D3384-043 to D3372-051 using 1/4"-20 socket head cap screw and washers as per Dwg D3371. Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>AN960-416</td> <td>Washer</td> <td>M 5519</td> </tr> <tr> <td>1</td> <td>HX-81</td> <td>1/4"-20 SHCS 3/8" long</td> <td>M 16520</td> </tr> </tbody> </table> Identify as D3372-041 & attach keys Record the Key Number on page 4	Qty	Part Number	Description	Batch	2	AN960-416	Washer	M 5519	1	HX-81	1/4"-20 SHCS 3/8" long	M 16520	SB	05-01-26	29																
Qty	Part Number	Description	Batch																														
2	AN960-416	Washer	M 5519																														
1	HX-81	1/4"-20 SHCS 3/8" long	M 16520																														

RELEASED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05/01/26	13	stock 2x D3372-1	LI	05-01-26	2	LI	LI 050126	
05/01/29	22	stock 2x D3384-043	SM	05/01/29	2	SM	SM 050129	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	22167B
Description: Dual Disabling Device		Part Number:	D350-740-011
		Keyed:	<input type="checkbox"/> Alike <input type="checkbox"/> Unalike
Dwg: D3371 Rev. A; D3372 Rev. A		Qty:	15
		Page 3 of 4	

Step	Location	Procedure	By	Date	Qty												
24	QC5	Inspect work to Step 23			18												
25	PK	Ensure that keys are attached to D3371-041 and D3372-041 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3371-041</td><td>Pedal Lock Assembly</td><td>522167B</td></tr><tr><td>1</td><td>D3372-041</td><td>Collective Lock Assembly</td><td>222167B</td></tr></table> Ensure that keys can be locked and unlocked for each D3371-041 and D3372-041 assembly.	Qty	Part Number	Description	Batch	1	D3371-041	Pedal Lock Assembly	522167B	1	D3372-041	Collective Lock Assembly	222167B			18
Qty	Part Number	Description	Batch														
1	D3371-041	Pedal Lock Assembly	522167B														
1	D3372-041	Collective Lock Assembly	222167B														
26	QC4	Inspect Kit 100% for Completeness on the W/O	CL	05/02/01	18												
27	PK	Identify and pack for shipping as per PPP D350-740-011	CL	05/02-01	18												
28	AC	Cost / part: <u>D3372-041</u> <u>ONLY</u>	SAC	05.02.26	18												
29	DC	Close W/Order and Ensure Travelers Attached Inspect Level 21 Travelers: D350-740-011 D3371-1 / D3371-3 D3372-1 / D3372-7 D3373-7 / D3373-11 D3384-1 / D3385-1	HJ	05.04.12	18												
****Remember to record key numbers on page 4																	

PTO

RELEASED
JAN 15 2013

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector	
05-02-01	25	Stock 18 x D3372-041	<i>CL</i>	05/02/01	18	<i>CL</i>	<i>CL</i>	

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 12, 2005
01:18 pm

Work Order No : 0022167
Project Name : D350-740-011
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : *D350-740-011
Description : Lock Out Kit
Manufactured : No
Amount Req'd : *015*
Amount Done : 0
Start Date : 01-10-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

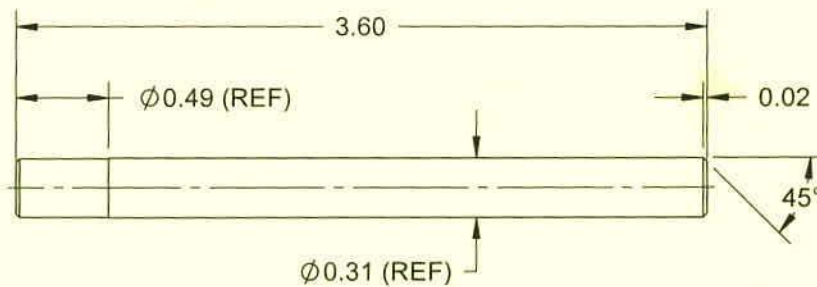
Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. A SHEET 1 OF 1
DATE 05.01.10	TITLE COLLECTIVE LOCK		SCALE 1:1



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D3372-3 GUIDE

NOTES:

- 1) MATERIAL: AN5-42A BOLT MODIFIED AS SHOWN.
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

NO. 22167B

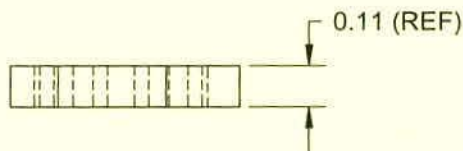
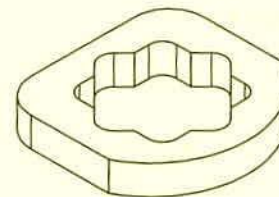
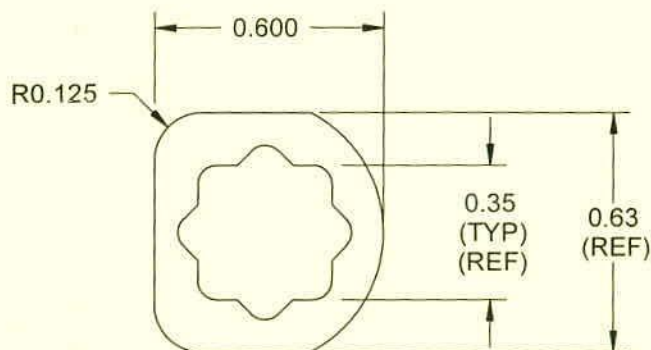
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PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. A SHEET 1 OF 1
DATE 05.01.10	TITLE COLLECTIVE LOCK		SCALE 2:1

SPECIFICATION CONTROL DRAWING



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IMMEDIATE NOTICE

WORK ORDER

NO. 22167B

D3372-11

NOTES:

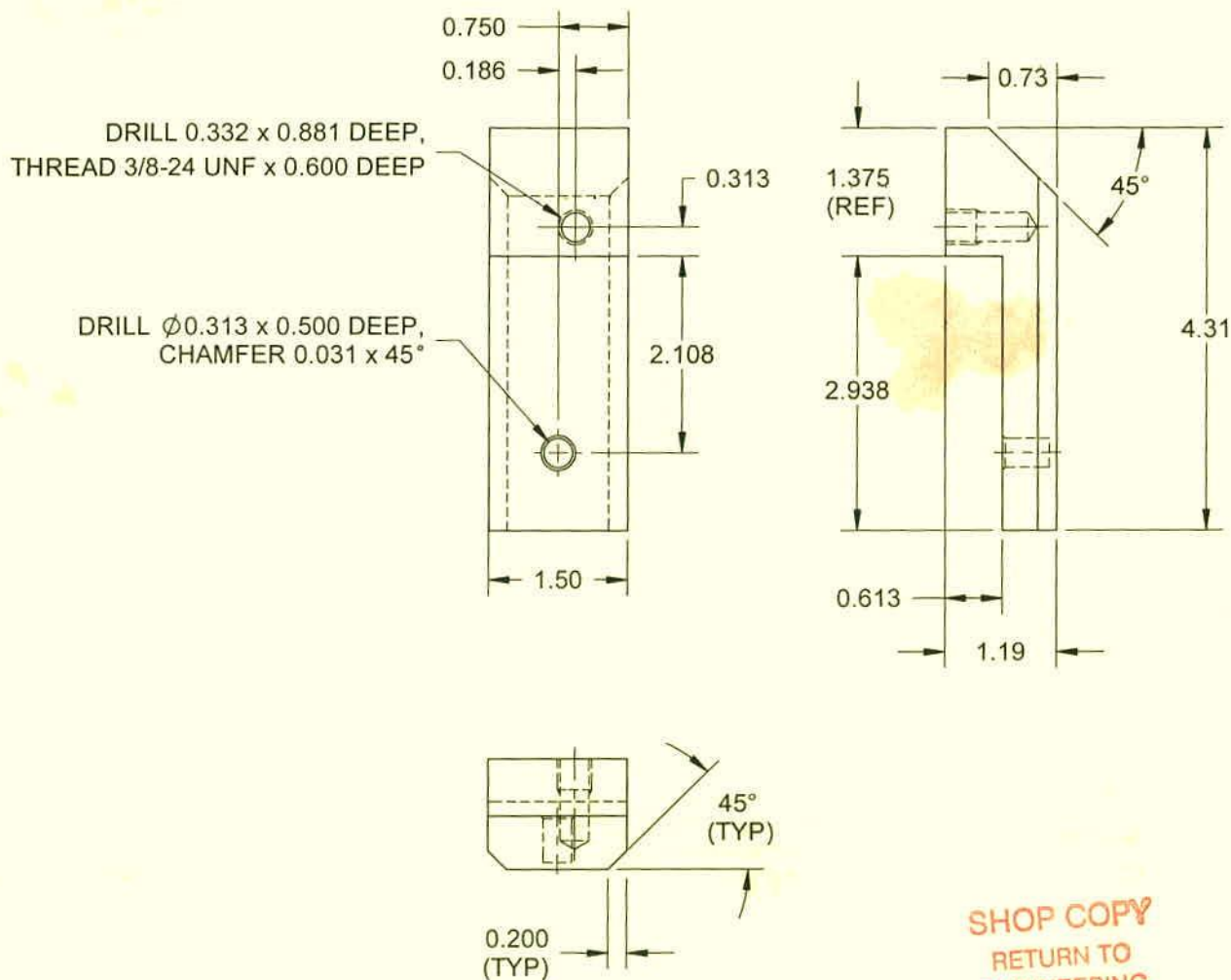
- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3372	REV. A SHEET 1 OF 1
DATE 05.01.10	TITLE COLLECTIVE LOCK		SCALE 1:2



D3372-7 SLIDER BODY

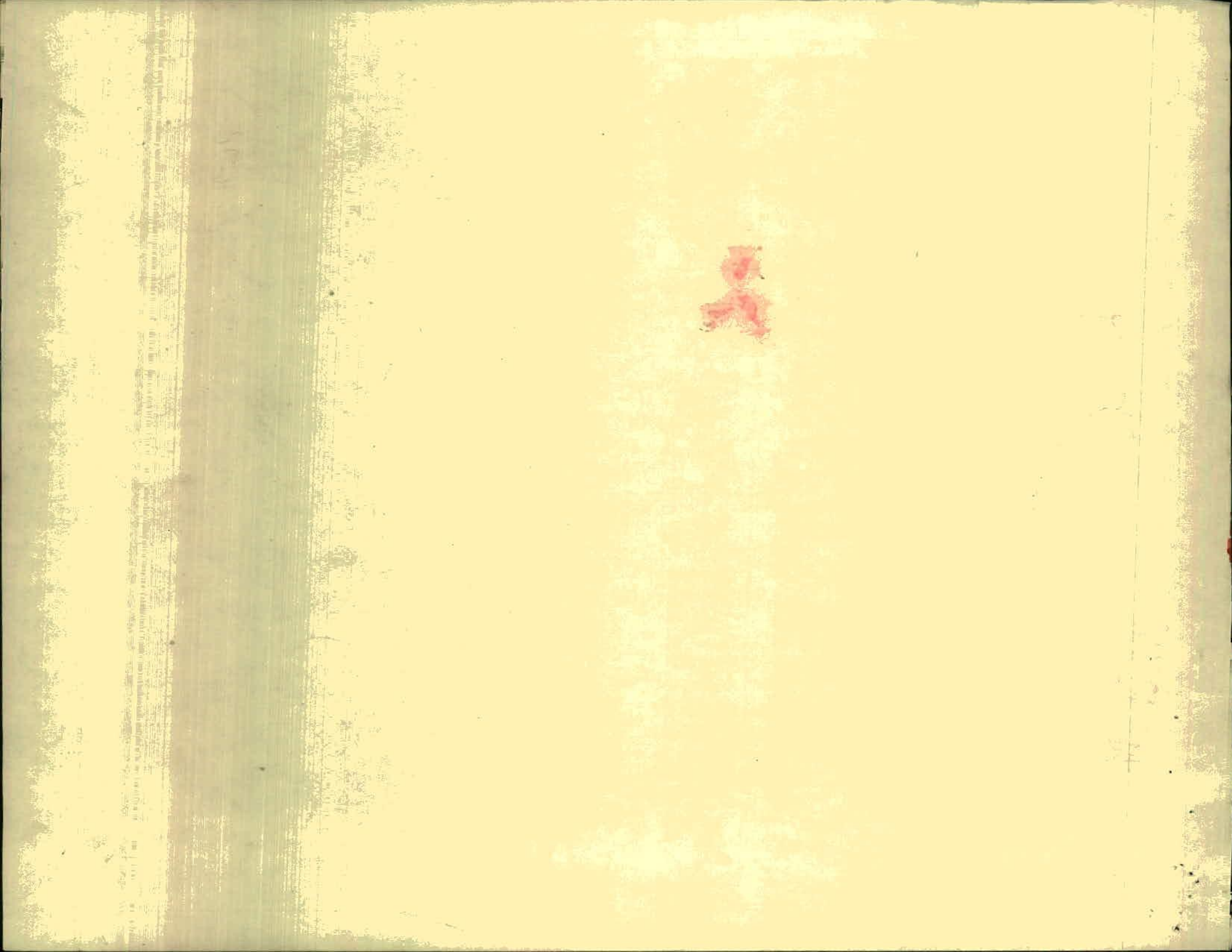
NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 004.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER
NO. 22167B

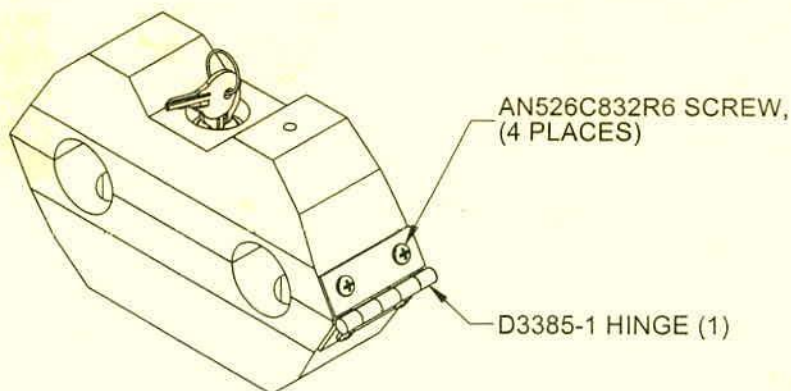
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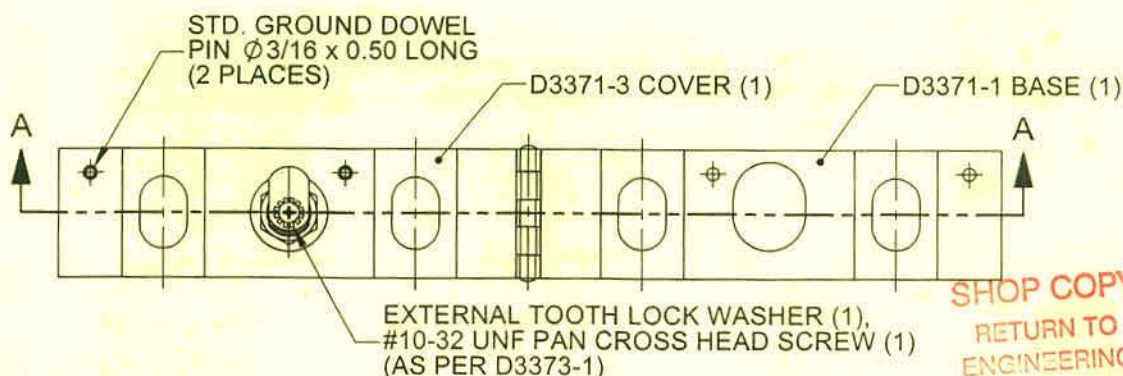
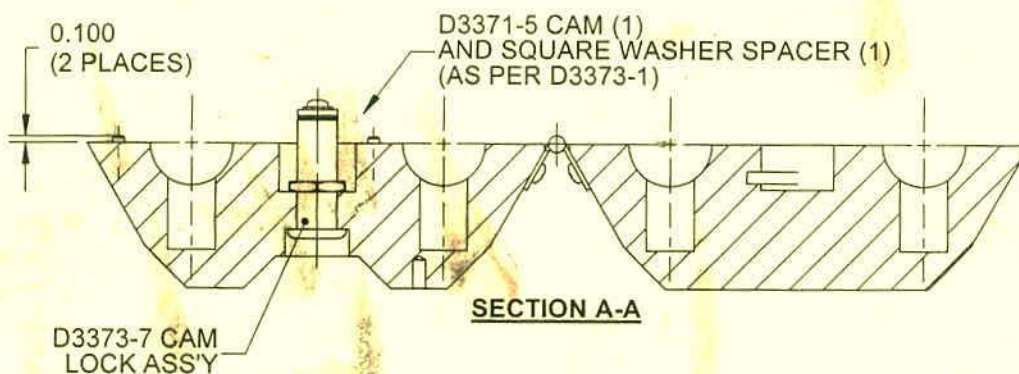


PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. A SHEET 1 OF 4
DATE 04.12.16	TITLE PEDAL LOCK		SCALE 1:3
A	04.12.06	NEW ISSUE	



DETAIL B: (PEDAL LOCK SHOWN LOCKED WITH KEY)



D3371-051 PEDAL LOCK ASSEMBLY

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WORK ORDER
NO. 22167B

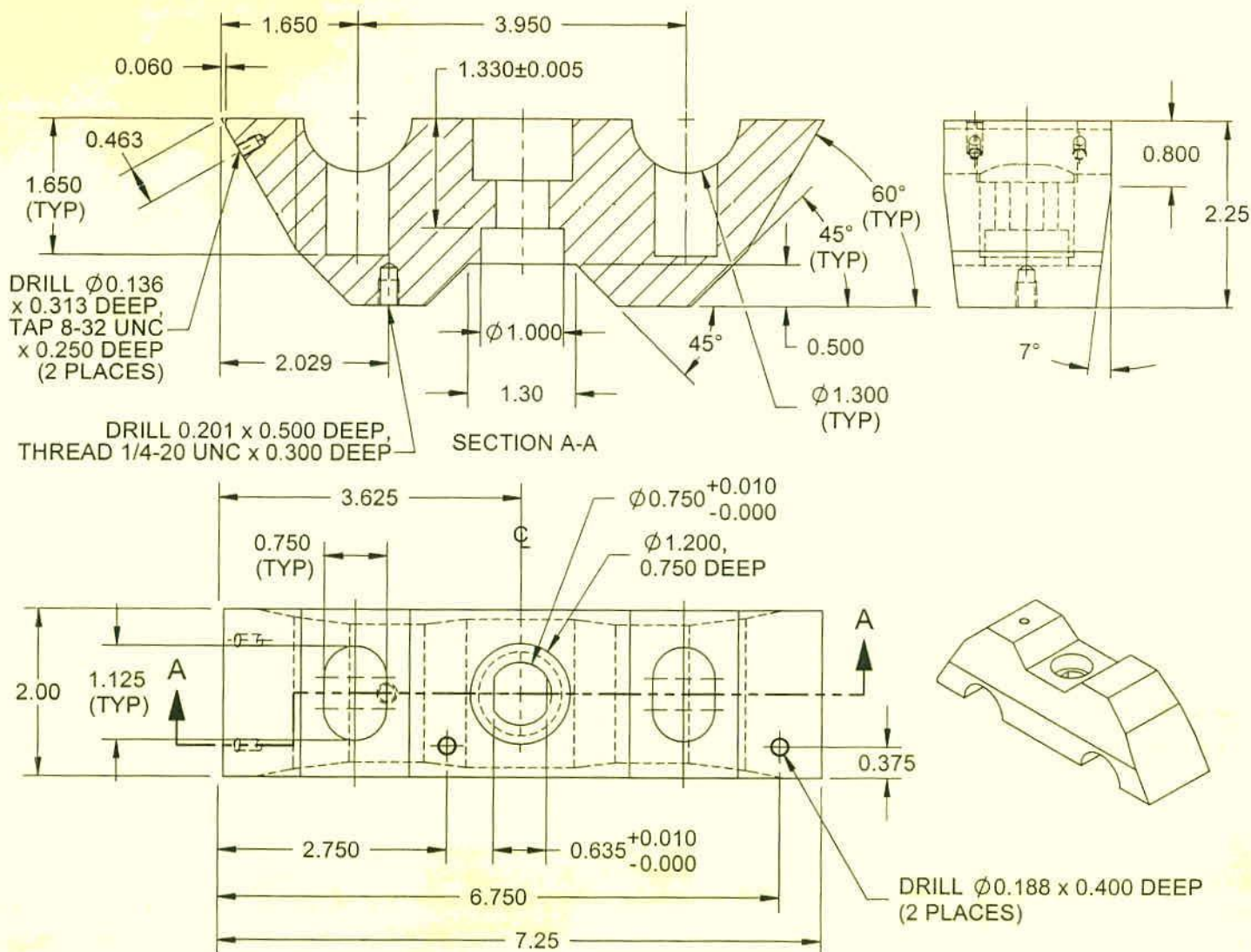
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3002176

PRELIMINARY ISSUE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. A SHEET 3 OF 4
DATE 04.12.16		TITLE PEDAL LOCK	SCALE 1:2



D3371-3 COVER

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8) (REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER

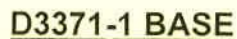
22167B

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3371	REV. A SHEET 2 OF 4
DATE 04.12.16		TITLE PEDAL LOCK	SCALE 1:2



1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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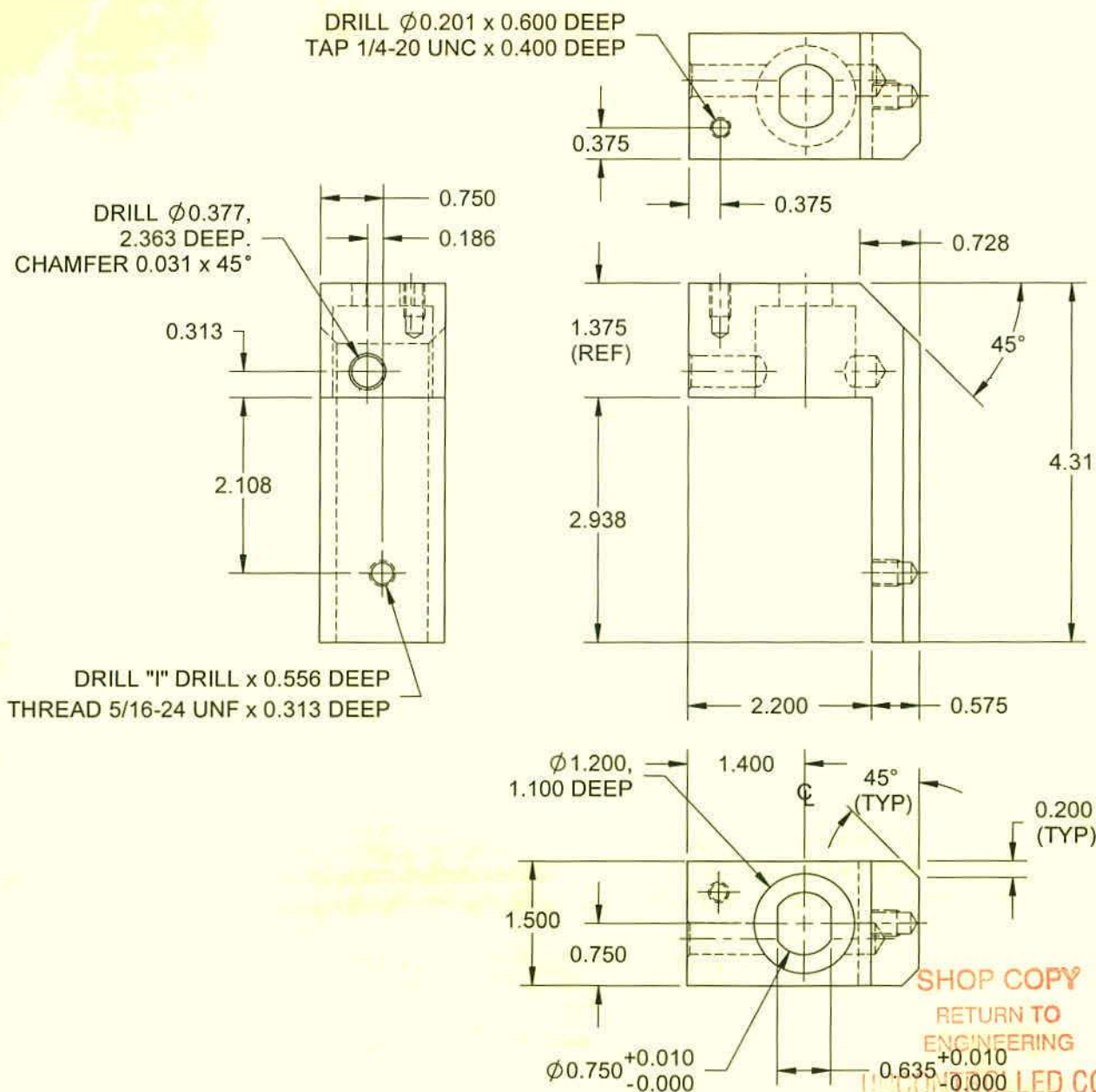
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ЕВРОПЕЙСКИ

PRELIMINARY ISSUE

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CHECKED	APPROVED	DRAWING NO. D3372	REV. A SHEET 1 OF 1
DATE 05.01.10		TITLE COLLECTIVE LOCK	SCALE 1:2



D3372-1 MAIN BODY

NOTES:

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 004.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

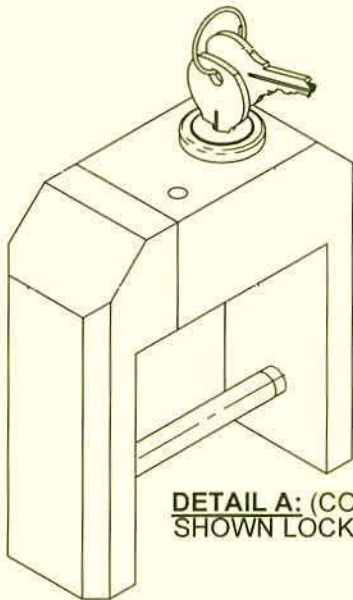
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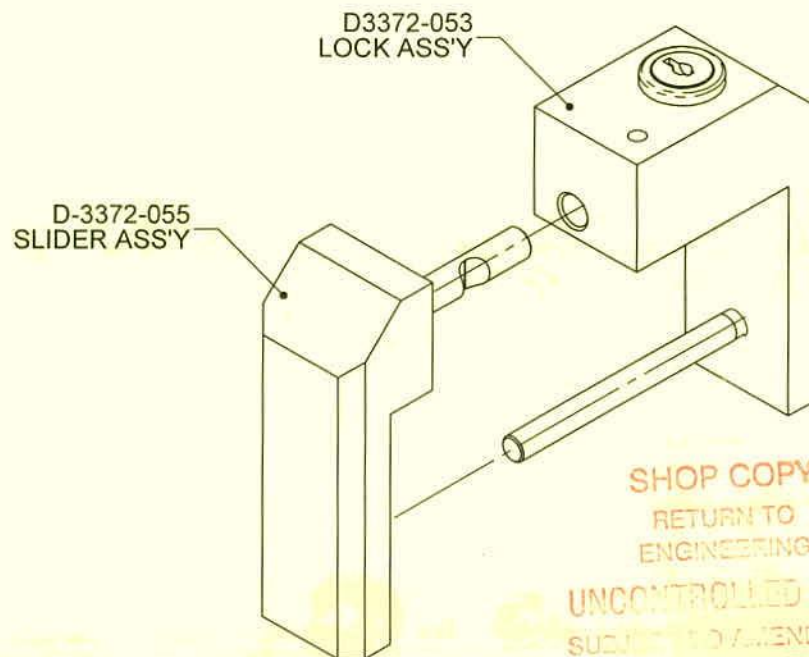
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PRELIMINARY ISSUE

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DATE	05.01.10	TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	



DETAIL A: (COLLECTIVE LOCK
SHOWN LOCKED WITH KEYS)



D3372-051 COLLECTIVE LOCK ASS'Y

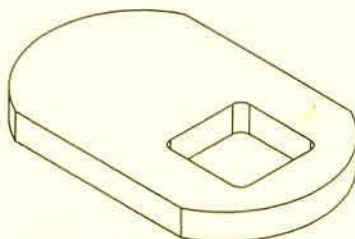
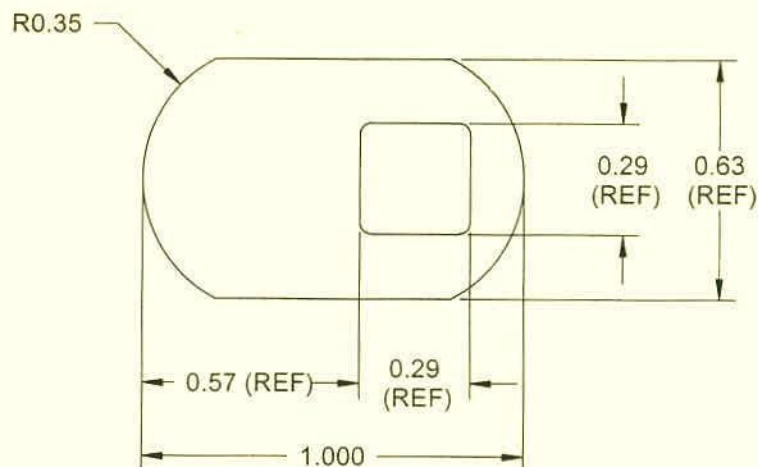
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11
MOBILE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO D3371	REV. A SHEET 4 OF 4
DATE 04.12.16		TITLE PEDAL LOCK	SCALE 2:1



D3371-5 CAM

NOTES:

- 1) MATERIAL: SUPPLIER BY D3373, MODIFIED AS SHOWN
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

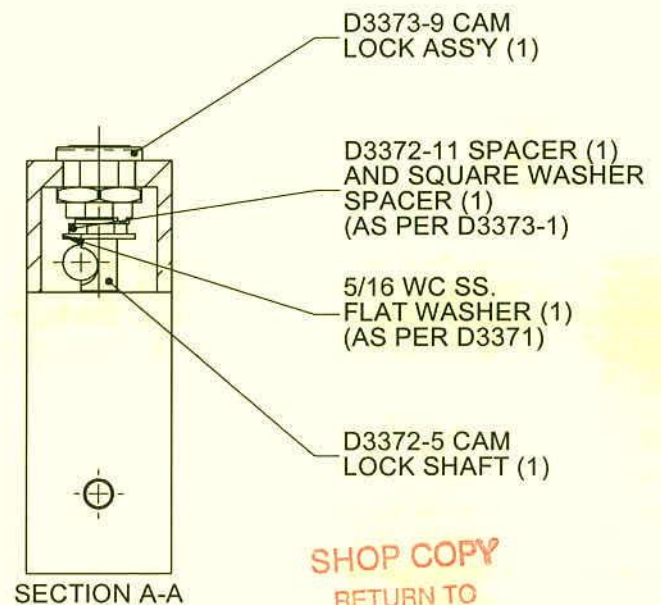
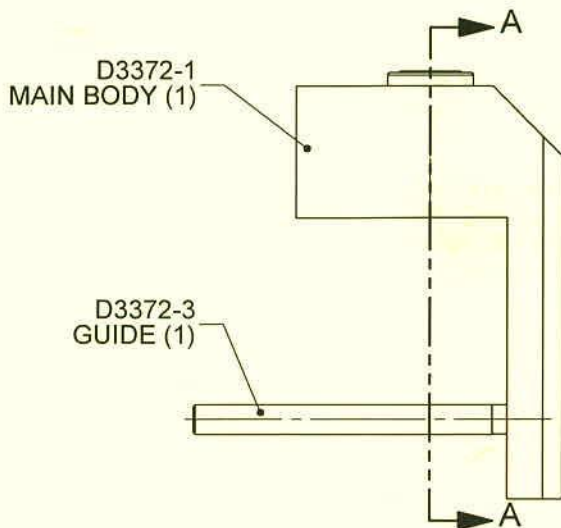
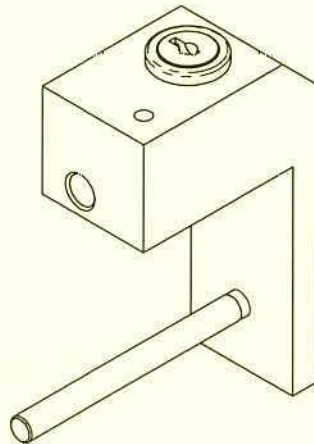
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PRELIMINARY ISSUE

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DATE 05.01.10		TITLE COLLECTIVE LOCK	SCALE 1:2
A	05.01.10	NEW ISSUE	



D3372-053 LOCK ASS'Y

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